

Work Order ID 67186

Wednesday, March 09, 2011 2:30:44 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

11-03-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *M114649*

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

SY 11.03.17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC 11.03.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/4/03/18

FD

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

1 BR 11-3-08.

Hand Finishing

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 9:15

OVEN TEMPERATURE: 1100°

FINISH TIME: 9:45

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 BR 11-3-20

140

QC3- Insp Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 24 11/03/20

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: w/o
D350-607-043 / B67184

0.00

0.00

Memo

x1 0 el 11/03/28

Packaging

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

CR 11/03/29

ME

11-03-29

Dart Aerospace Ltd

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Picklist Print

Wednesday, March 09, 2011 2:30:53 PM

Page 1

Work Order ID: 67186

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1		Manufactured	No			100	Each	7.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
					63628			1					
					64651			6					
✓ D2221-5		Manufactured	No			100	Each	4.0000	2	2			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					64652			4					
✓ D2221-7		Manufactured	No			100	Each	2.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					64653			2					

11.03.14
 1x
 11.03.14
 2x
 11.03.14
 1x

Dart Aerospace Ltd

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Page 2

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3
Basket Hinge

Manufactured No

100 Each

12.0000

2

2



SY 11.03.14

Location

Loc Qty

Loc Code

WA

12

65418

6

66894

6

(2x)

* D2235-1
Basket Rib

Manufactured No

100 Each

14.0000

2

2



B64626 (2x) *SY* 11.03.14

Location

Loc Qty

Loc Code

WA

14

64898

4

66086

10

✓ D2581
Mounting Bracket

Manufactured No

100 Each

60.0000

2

2



SY 11.03.14

Location

Loc Qty

Loc Code

WA

60

65950

12

66500

24

66806

24

(2x)

/ D3442-1
Shim

Manufactured No

100 Each

23.0000

2

2



SY 11.03.14

Location

Loc Qty

Loc Code

ST

8

64271

8

WA

15

65783

15

(2x)

Wednesday, March 09, 2011 2:30:54 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D2221


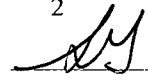
Parent Item Name: 350 Basket Base


Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00


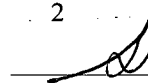
Required Qty: 1.00


✓ D3825-041 Manufactured No 100 Each 6.0000 2 2   11.03.14


Rib Assembly (Basket End)

Location Loc Qty Loc Code

WA 6
65419 6

✓ D3826-041 Manufactured No 100 Each 6.0000 2 2   11.03.14


Rib / Gusset Assembly

Location Loc Qty Loc Code



WA 6
65420 6


✓ D3827-041 Manufactured No 100 Each 8.0000 1 1   11.03.14


Rib Assembly (Inboard)

Location Loc Qty Loc Code

WA 8
64857 2
65485 6

✓ D3832-1 Manufactured No 100 Each 2.0000 1 1   11.03.15


Mesh (Base)

Location Loc Qty Loc Code

WA 2
65313 2

Wednesday, March 09, 2011 2:30:54 PM

Shop Packet Print

Page 3

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Wednesday, March 09, 2011 2:30:54 PM

Page 4

Work Order ID: 67186

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-1

Manufactured No

100

Each

16.0000

2

2



Mesh (Base End Face)



LY 11.03.15

Location

Loc Qty

Loc Code

WA

16

64246

2

64891

6

65937

8

(2)

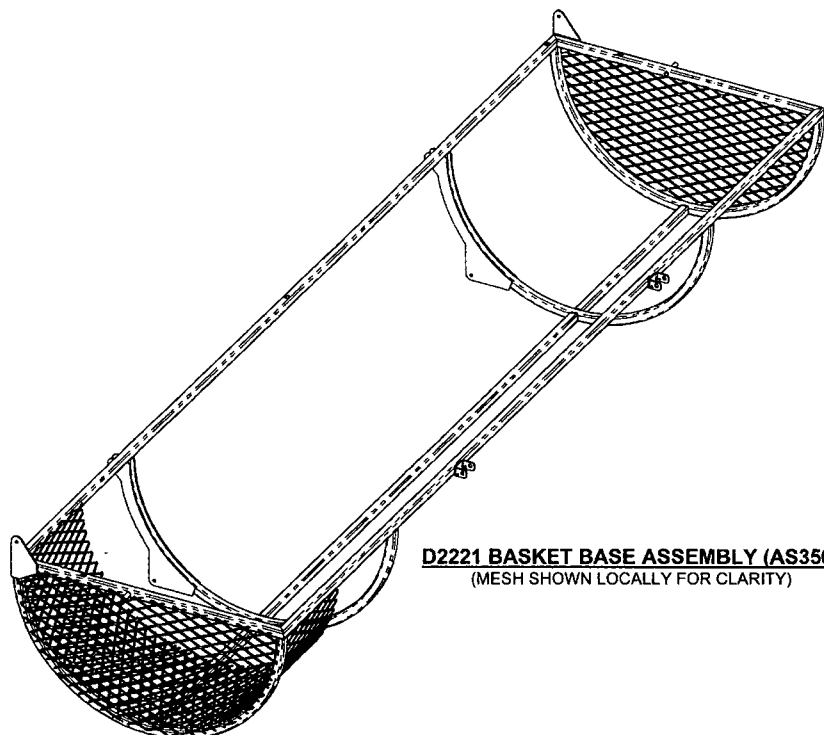
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITH
WORK ORDER
NO. 97189
pl 11-03-9



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
05/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. H
MFG. APPR.	BS	D2221	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

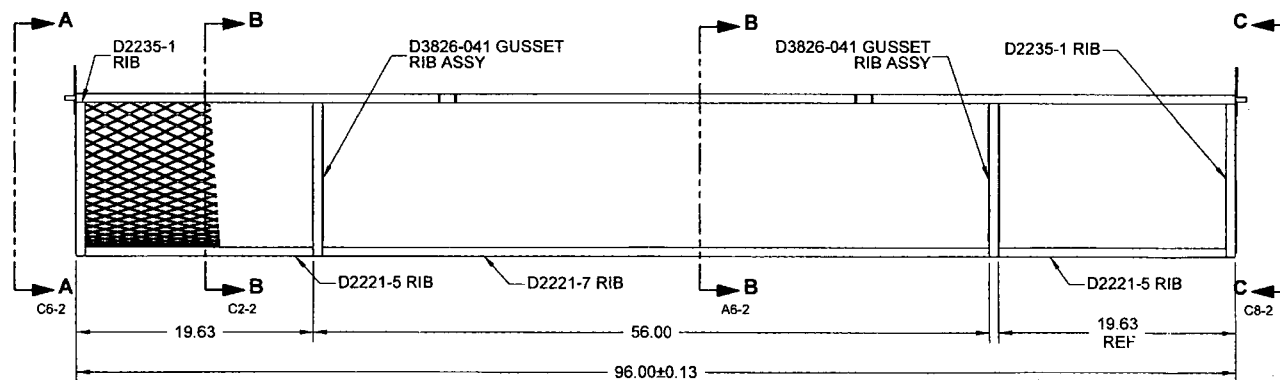
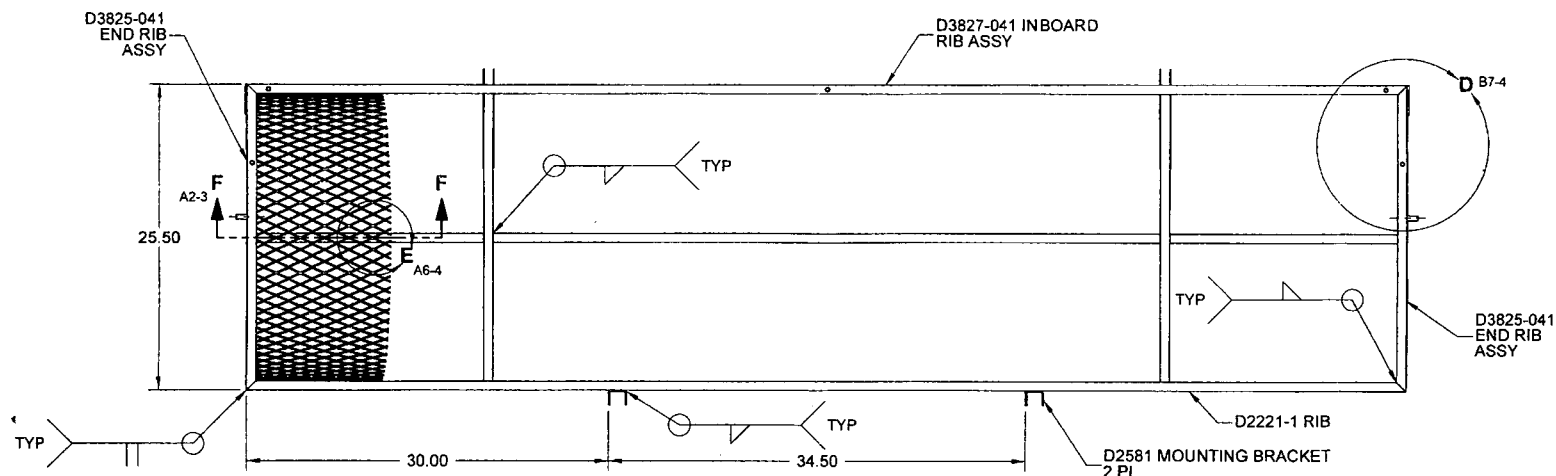
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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w/b 6-1184

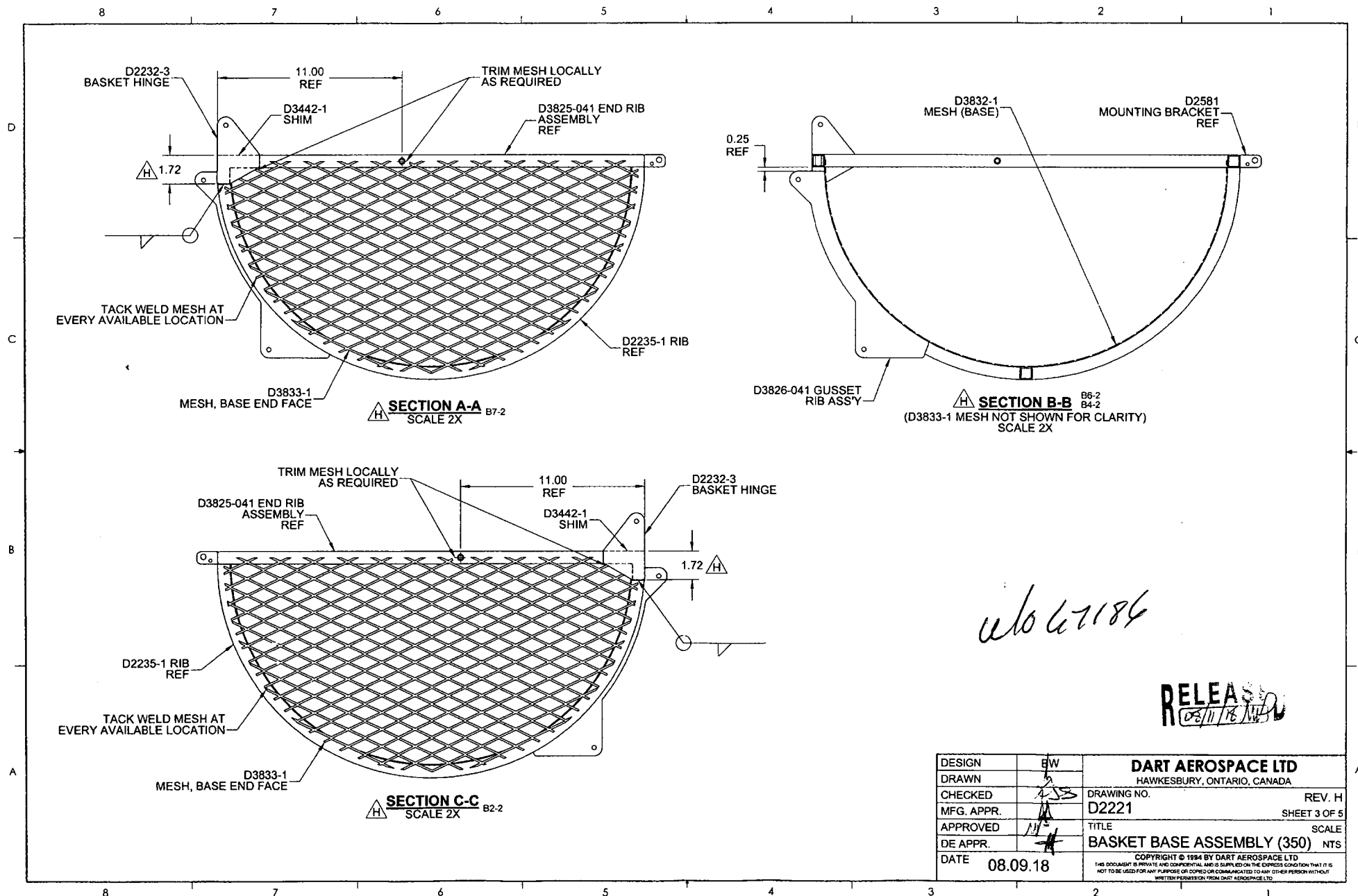
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8 7 6 5 4 3 2 1

D

C

B

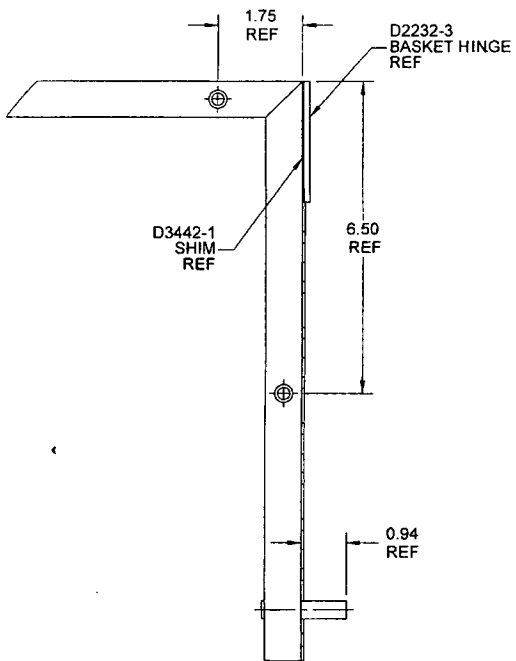
A

D

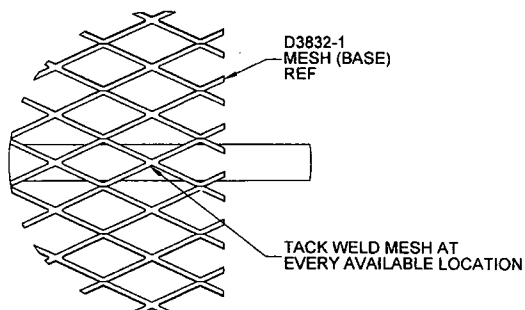
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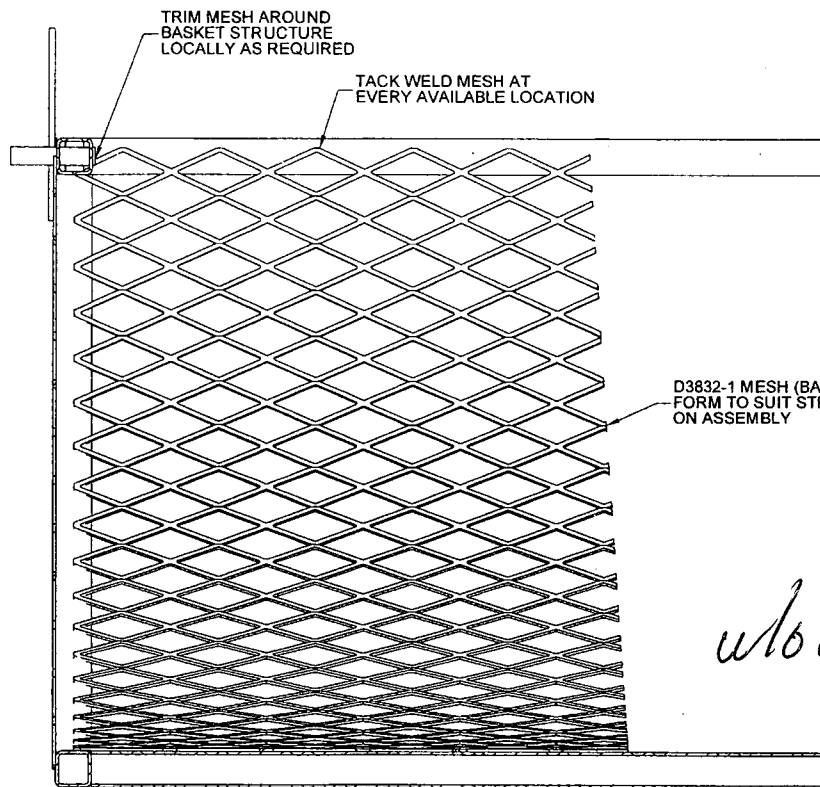
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DETAIL D D2-2
SCALE 4X



DETAIL E C8-2
SCALE 4X



SECTION F-F D7-2
SCALE 4X

W1062185

RELEASED
02/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>TH</i>	D2221	SHEET 4 OF 5
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

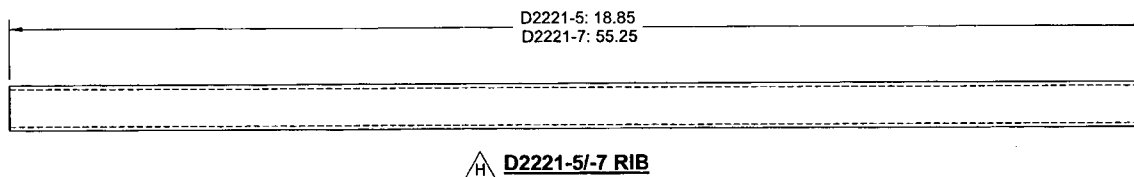
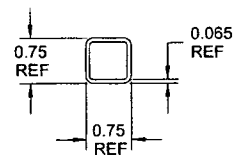
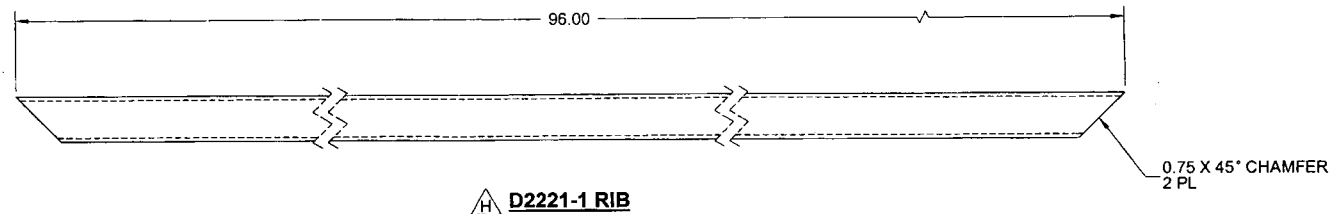
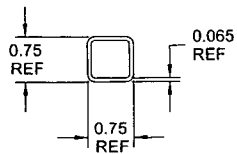
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08/11/18

u647186

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries